

Work Order ID 80730

February-28-12 10:33:02 AM

80730

Page 1

Item ID: D3319-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearplate

Start Date: 28/02/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 13/03/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/02/28

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3319

Rev B

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1010 049

1-Cut as per Dwg D3319

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

B12-3-5

(10)

B12-3-5

S 12/03/15

(X10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Item ID: D3319-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate
 Start Date: 28/02/2012 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 13/03/2012 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140	NC BRAKE	0.00							
140									
Brake NC	Memo	0.00							
Brake NC	1- Form using DT8326 & DT8261 as per Dwg D3319Rev: <u>B</u>			12/03/07					
	2- Form flat on press using DT8776 block								

150	QC6- Inspect dimensions to drawing	0.00							
150									
QC	Memo	0.00							
Quality Control									

160	Weld per dwg A/R Hardcoat steel Batch: <u>119712</u>	0.00							
160	Large Fab								
Large Fab	Memo	0.00							
	1- Layout weld location as per Dwg D3319 using jig D3319-1T3								
	2- Weld hard surface using DT8755 per QSI 004 and Dwg D3319 Rev: <u>B</u>								
	Qty Part Number Description Batch								
	A/R N/A 228/7560 Hardcoat Rod <u>119712</u>								

(8) me/MAL 2012-03-09

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 Start Date: 28/02/2012 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 13/03/2012 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170 QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

190

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

190

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11h10

320°F

11h48

m18 489

10 12/03/12.

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Page 4

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 Required Date: 13/03/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC3- Inspect Part Finish	0.00							
200									
QC	Memo	0.00							
Quality Control									
210	Packaging	0.00							
210									
Packaging	Memo	0.00							
Packaging	Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3319-1, B/N: BXXXXX For Product Eligibility see PDA05-18 and Stock Location: _____								
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

6/2/3/12 (S)

(S) SP12-03-12

12/3/13 (S)

12-03-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

February-28-12 10:33:06 AM

Page 1

Work Order ID: 80730

80730

Parent Item: D3319-1

D3319-1

Parent Item Name: Wearplate

Start Date: 28/02/2012

Required Date: 13/03/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: B05.10.14Added step 9. dwg rev B KJ/EC
IPP Rev:C Now on Waterjet 06-10-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S18GA		Purchased	No			100	sf	204.8000	0.628	6.610526			

M1010S18GA

1010/1025 SHEET .048

**

B 12-3-0

Location

Loc Qty

Loc Code

MAT019

204.8

116268

10

117806

194.8

116268

10

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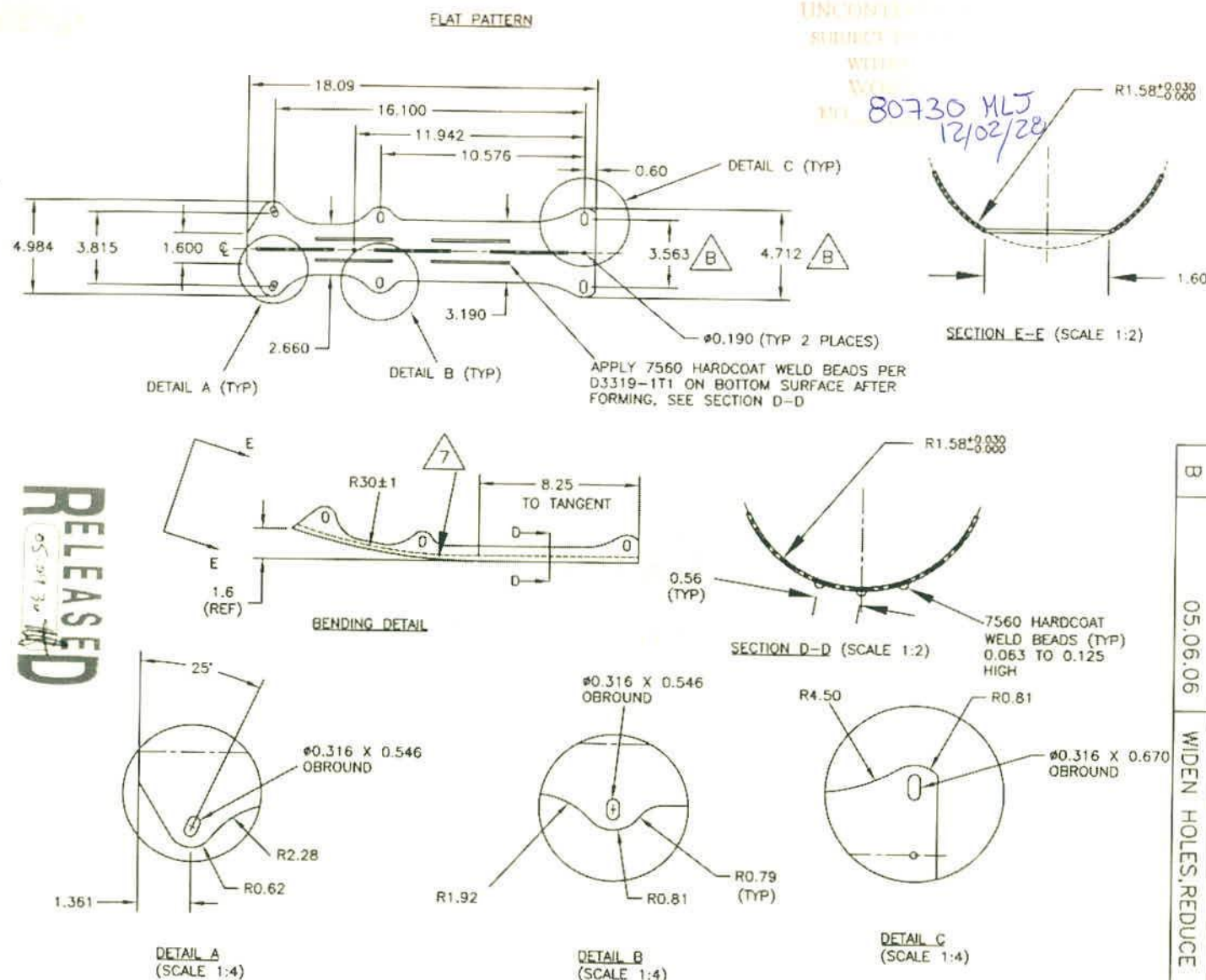
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
41	44	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
05.06.06	04.09.24	D3319
DATE	05.06.06	TITLE
		WEARPLATE
		NEW ISSUE
		WIDEN HOLES, REDUCE WIDTH -3/-5/-7
		SCALE
		1:8



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

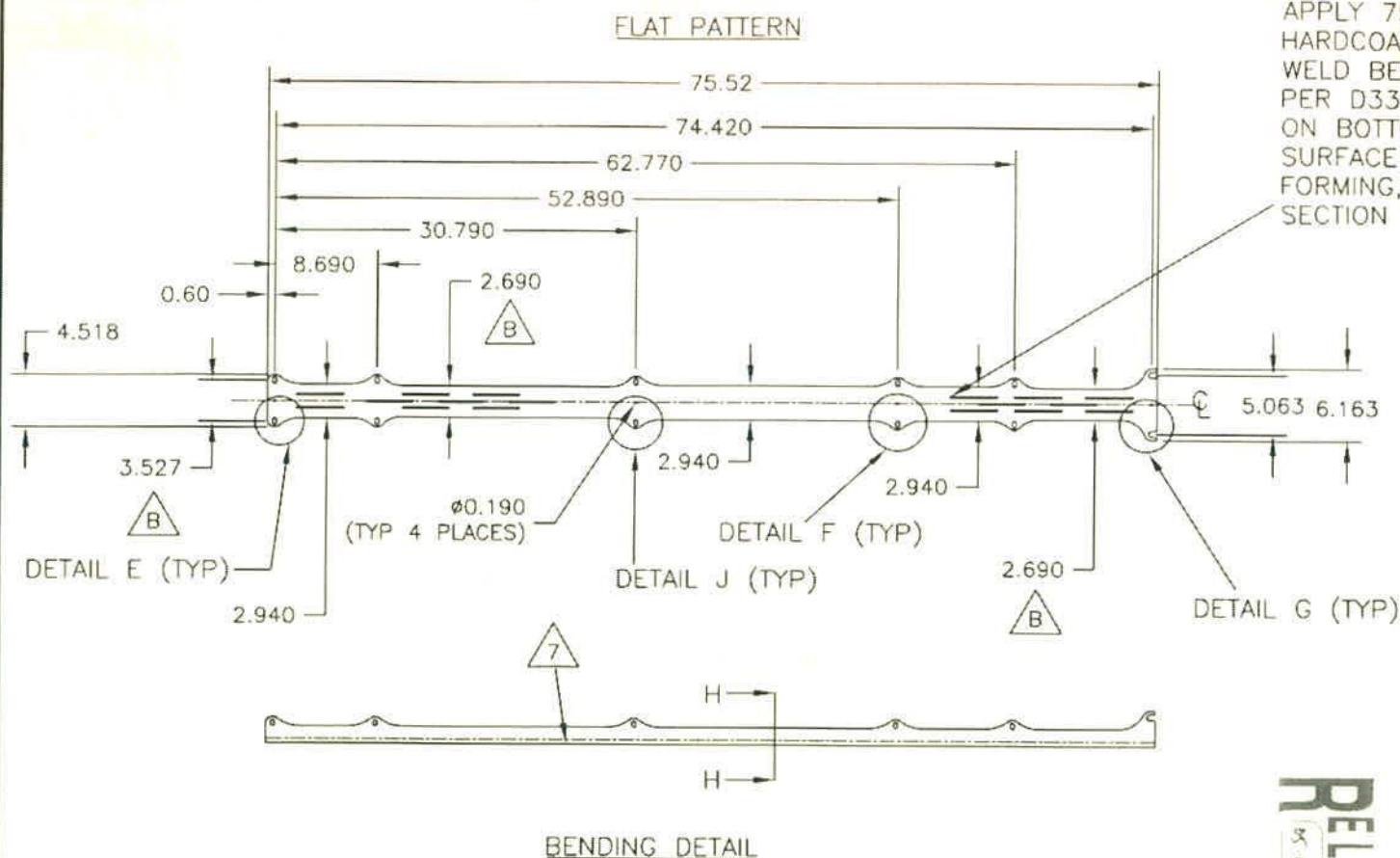
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DART

APPLY 7560
HARDCOAT
WELD BEADS
PER D3319-3T1
ON BOTTOM
SURFACE AFTER
FORMING, SEE
SECTION H-H

**RELEASED**

D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DESIGN	CH	DRAWN BY	CH	DART AEROSPACE LTD
CHECKED	CH	APPROVED	CH	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	DRAWING NO.	D3319	REV. B
		TITLE	WEARPLATE	SHEET 2 OF 5
		SCALE	1:15	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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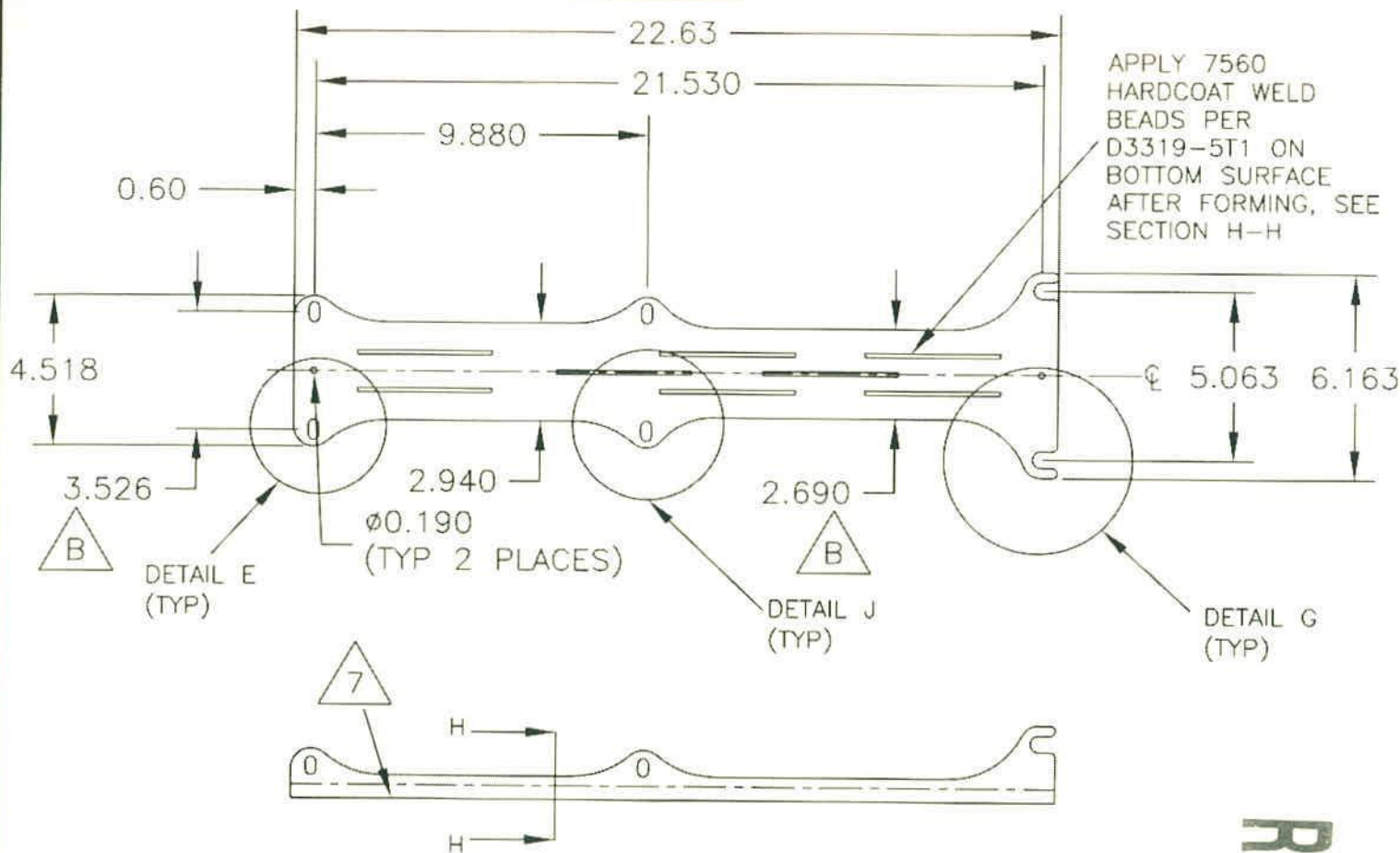
NOTE: Date & initial all entries

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DART**DART AEROSPACE LTD**

HAWKESBURY, ONTARIO, CANADA

DESIGN	DRAWN BY	DRAWING NO.	REV. B
041	044	D3319	SHEET 3 OF 5
CHECKED	APPROVED	TITLE	SCALE
05.06.06	05.06.06	WEARPLATE	1:5

FLAT PATTERNBENDING DETAILD3319-5 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

RELEASED

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

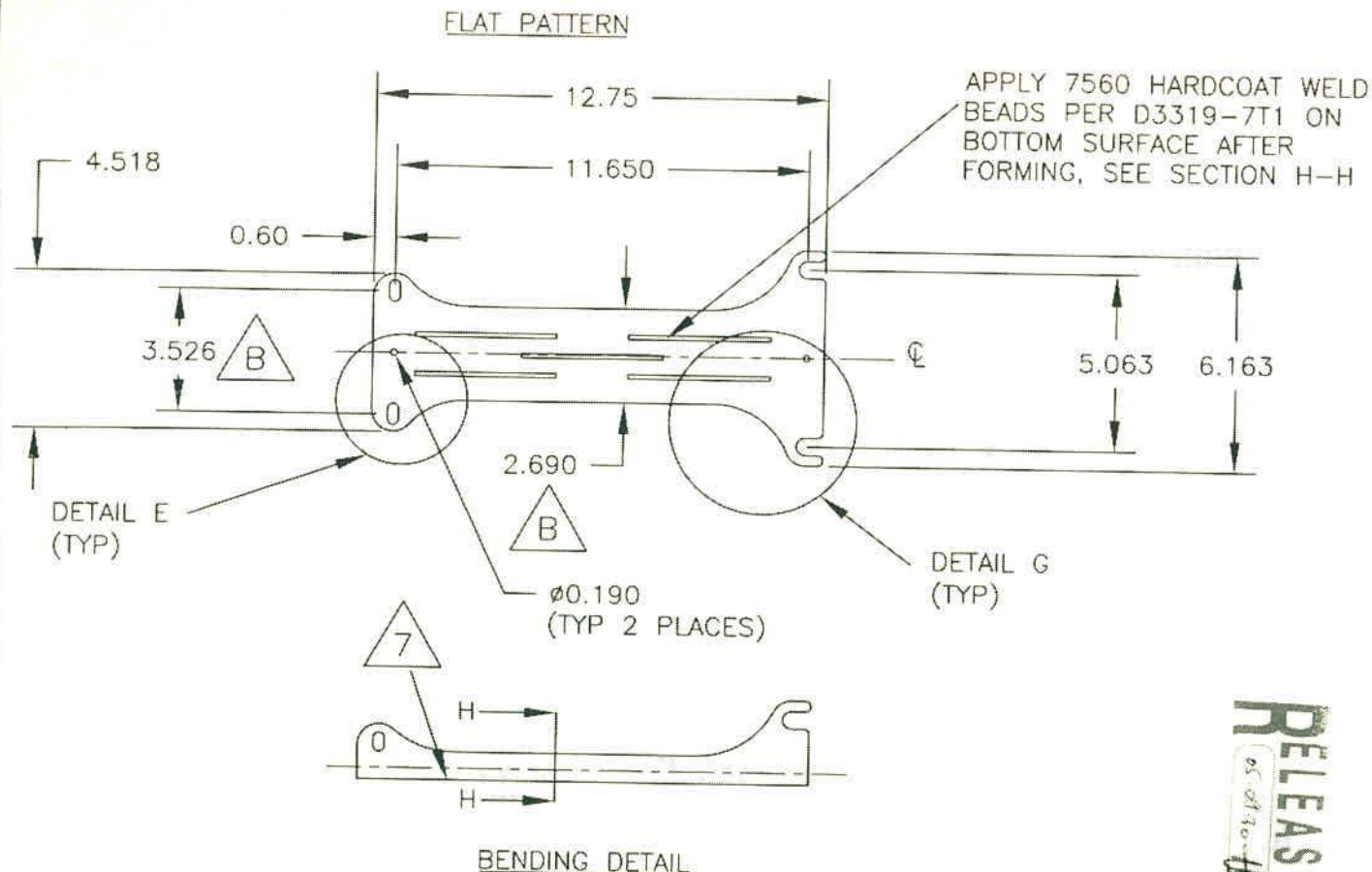
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CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	DRAWING NO.	D3319	REV. B
		TITLE	WEARPLATE	SHEET 4 OF 5
		SCALE	1:5	

RELEASED
05.01.30.11**D3319-7 WEARPLATE**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
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- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

W/O:		WORK ORDER CHANGES					
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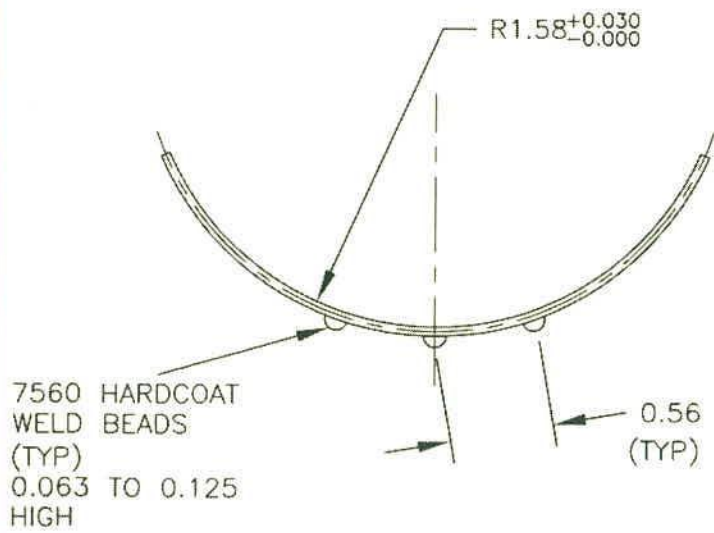
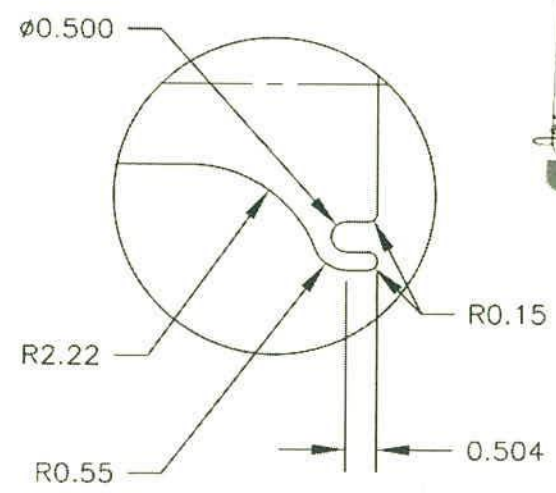
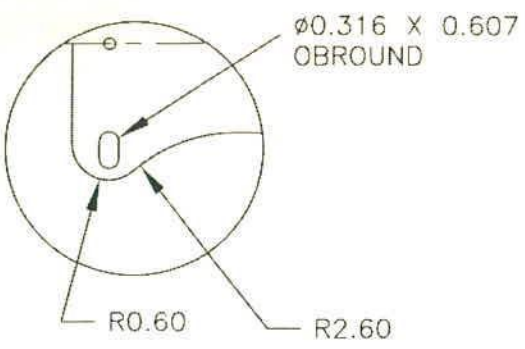
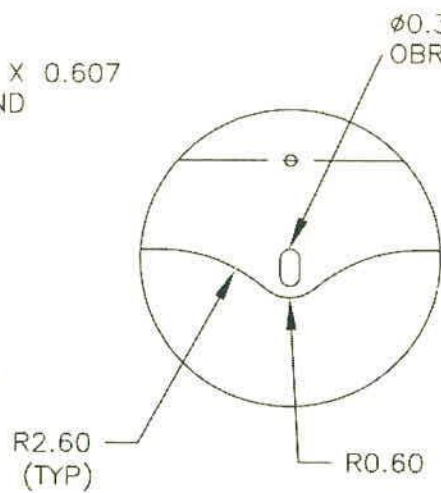
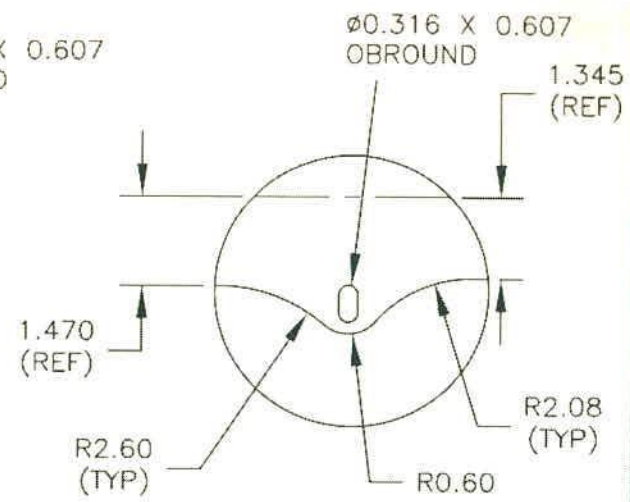
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CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	TITLE	WEARPLATE	REV. B
		DRAWING NO.	D3319	SHEET 5 OF 5
		SCALE	1:3	

RELEASED
05 09 30 11



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